

Date: Monday, 2/27/2006 4:08:05 PM  
 User: Kim Johnston

## Process Sheet

*Never pulled  
 not skc  
 removed from Apple  
 07/01/17*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT  
 Job Number : 25943A  
 Estimate Number : 10176  
 P.O. Number : *N/A* Part Number : D2563  
 This Issue : 2/27/2006 S.O. No. : *N/A* Drawing Number : D2563 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : C  
 Previous Run : 25558A Material : *N/A*  
 Written By : *See COMMENT BELOW* Due Date : 3/17/2006 Qty: 10 Um: Each  
 Checked & Approved By : *06.02.28*  
 Comment : Est Rev:G 02.07.31 Re-format Location RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2244116 Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: *20457*

*RE-06-03-29 10*

2.0 D267334 End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	<i>325386</i>

Batch

*325386*

*RE-06-03-29 10*

3.0 D2561 Lug Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	<i>325088 = (9) B25968 = (11)</i>

Batch

*325088 = (9) B25968 = (11)*

*RE-06-03-29 10*

4.0 D2564 Mounting Angle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	<i>324496</i>

Batch

*324496*

*RE-06-03-29 10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25943A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

PE. 06.03.30 10

2-Deburr ends

PE. 06.04.3 10

3-Weld (1 End Only) as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838

PE. 06.04.4 10

4-Grind

FF 06.04.05 10

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-04-05

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:04:08 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06 04 10 (10)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

PE. 06.04.12 10

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838

PE 06.04.12 10

3-Grind

FF 06.04.17 10

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PE 06-04-17 (10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Date: Monday, 2/27/2006 4:08:05 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 25943A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then *a.m 06-04-18*

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*a.m 06-04-18*

*(10)*

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

*FC 06 04 18*

*(10)*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 04 18*

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*FC 06 04 18*

Job Completion



*u 06-04-10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

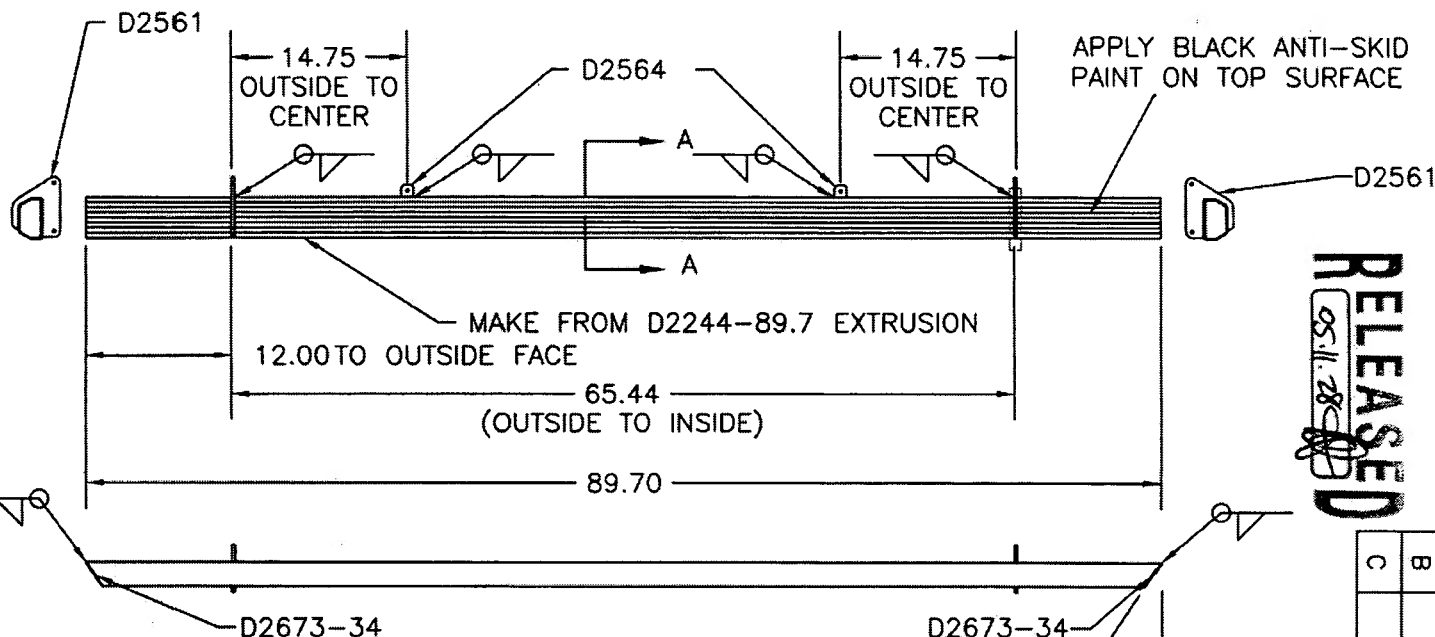
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
05.11.28

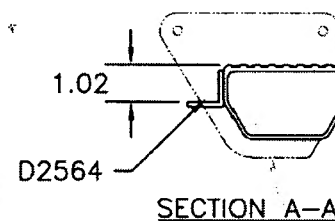
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	44	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
44	44	D2563	
DATE	TITLE	SCALE	
05.11.14	STEP WELDMENT ASSEMBLY	1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	



#### D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

\*cut per drawing



SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 2543A

#### D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Date: Monday, 2/27/2006 4:07:57 PM  
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## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 205 STEP(STANDARD HEIGHT)
<b>Job Number</b> : 25943	
<b>Estimate Number</b> : 10180	
<b>P.O. Number</b> :	<b>Part Number</b> : D205633011
<b>This Issue</b> : 2/27/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 24478	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 3/17/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>AS 06.02.28</i>	
<b>Comment</b> : Est Rev:F 02.07.11 Reformat; Removed D3010 RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	25943A	STEP WELDMENT
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**Comment:** Sub-Component STEP WELDMENT

2.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP205-633-011 CHG001

*KS 06-02-28*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2021101	Eyebolt
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**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2021-101 Eyebolt *B23483* ✓

5.0	D2022101	Spacer
-----	----------	--------

**Comment:** Qty.: 2.0000 Each(s)/Unit    Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-101 Spacer *B23396* ✓



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer B24271 1ymc B25047 6mc ✓

7.0

D2562001

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-001 Strut B24392 4mc B24272 6mc ✓

8.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-101 Strut B26392 4mc B24273 5mc B25971 1mc ✓

9.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-103 Strut B26392 4mc B25972 6mc ✓

10.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-105 Strut B23184 1mc B26392 4mc B25973 6mc ✓

11.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-107 Strut B26392 4mc B25974 6mc ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Monday, 2/27/2006 4:07:57 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2565109

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-109 Strut B24277 ymlc B25975 6 mlc

13.0

D2565111

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-111 Strut B24278 1 mlc B25976 5 mlc  
B28392 4 mlc

14.0

AN45A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-5A Bolt M100089

15.0

AN46A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-6A Bolt M19278

16.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M18369

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/27/2006 4:07:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A Bolt M15072 /

18.0

AN56A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-6A Bolt M18576 /

19.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A Bolt M17566 /

20.0

AN960JD416

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416 Washer M100675 /

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M19185 /

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/27/2006 4:07:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 25943

Part Number: D205633011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	MS21042L4	Nut
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut M19099

23.0	MS21042L5	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut M19073

24.0	D2563	Step Weldment Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2563 Step Weldment 325943 A

25.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-011

Location: Rev. G

27.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion





**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		26519 643					
		24988 013					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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